

Work Order ID 55251

January 12, 2010 1:35:16 PM



Page 1

Item ID:	D4047-043	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Rib Assembly					
Start Date:	1/12/10	Start Qty:	1.00			
Required Date:	1/25/10	Req'd Qty:	1.00			
Reference:						

Approvals:	Process Plan:	<i>RI</i>	Date:	<i>10-1-12</i>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D4047	<i>PAT PA3</i>								

100	Weld per dwg A/R S.S. rod Batch: <i>421109213</i>	0.00							
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Large Fab									
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Large Fab	Memo	0.00							
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- 1- Cut as per dwg D4047-3
- 2- Drill and chamfer holes as per dwg D4047
- 3-remove identification markings
- 4- Weld bushing in rib and grind weld flush as per dwg D4047

110	QC5- Inspect part completeness to step on W/O	0.00							
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QC									
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Quality Control	Memo	0.00							
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PRELIMINARY ISSUE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55251

January 12, 2010 1:35:16 PM



Page 2

Item ID: D4047-043	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Rib Assembly					
Start Date: 1/12/10	Start Qty: 1.00		Cust Item ID:		
Required Date: 1/25/10	Req'd Qty: 1.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 	QC10- Inspect visual per QSI004- ground welds	0.00							
QC Quality Control	Memo	0.00				(X)			
130 	Identify as per dwg & Stock Location: <i>Drskel</i>	0.00							
Packaging Packaging	Memo	0.00							
140 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

*Prototype
test
10.01.30*

MF 10-1-19

POSITIVE RECALL

EFFECTIVE _____ AUTH _____

RELEASED _____ DATE _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 12, 2010 1:35:20 PM

Work Order ID: 55251



Parent Item: D4047-043



Parent Item Name: Rib Assembly

Start Date: 1/12/10

Required Date: 1/25/10

Comments: 1- assemble and weld as per dwg D3589 QSI004
IPP RevA: new issue DD 10/01/06 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D4021-9		Manufactured	No			100	Each	0.0000	2.0000			
Bushing												
M304TS0.750W.049		Purchased	No			100	f	48.4054	2.0666			
304 SQ Tube .75x.75x.049W												



855257

DD 10.01.14



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

48.4054

103240

1.5816

106604

4.9307

107460

29.2779

109087

12.6152

2.0666

SM 10/01/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

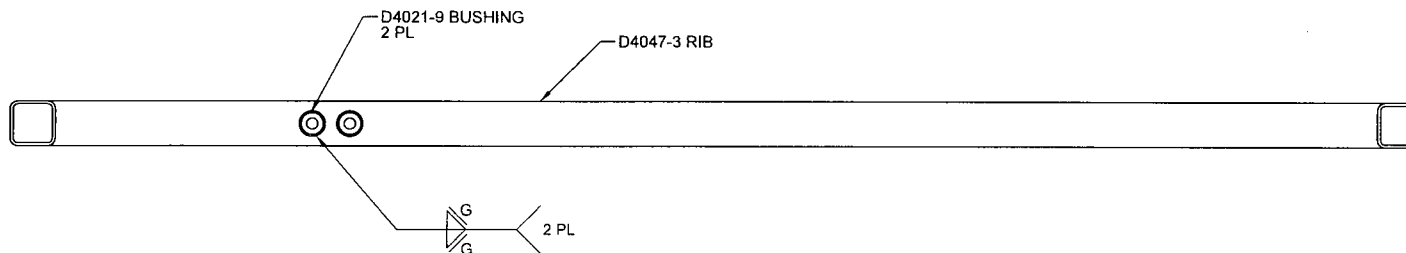
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -043	P/N	DESCRIPTION
	X	D4047-043	RIB ASSEMBLY
1	1	D4047-3	RIB
2	2	D4021-9	BUSHING



D4047-043 RIB ASSEMBLY

WLO 55251

PRELIMINARY ISSUE

10.01.18

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.88 lbs
- 8) WELD PER DART QSI 004

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO. D4047	REV. PA3
MFG. APPR.			SHEET 4 OF 6
APPROVED		TITLE	SCALE
DE APPR.		SHORT BASKET LID ASSY	NTS
DATE	10.01.18	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT BE NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

Receiving Report

Date: 8/8/09

Batch No: M108087

Supplier: MAGNA

Dart P/O: 7019

Packing Slip: Yes ☒ No ☐
 Invoice: Yes ☐ No ☒
 Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐ N/A ☐
 Waybill Attached: Yes ☐ No ☒
 Shipment Complete: Yes ☒ No ☐ N/A ☐
 QC6 Inspection 4/6/09 ☒ N/A ☒
 Work Order ☐ N/A ☒

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12 EC

Production/Admin:

Date

Received/Costing

Initial

08/09/09
RC 8763
CG

Location _____



Magna Stainless division de CSM Inc.

525 Meloche Ave., Dorval (Québec) H9P 2W2

Tél.: (514) 631-1211 • Fax: (514) 631-0013

Sans frais / Toll free: 1-800-363-6646

ISO 9001-2000

N° FACTURE / INVOICE NO.

164382

VENDU À - SOLD TO

DART

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY

ONTARIO

K6A 1K7

EXPÉDIÉ À - SHIPPED TO

MEME - SAME

DATE	N° LIVR. - DEL. NO.	PAR - VIA	N° COMM. DU CLIENT CUST. ORDER NO.	CONDITIONS - TERMS	N° T.V.Q. - Q.S.T. NO.	N° T.P.S. - G.S.T. NO.	
Aug29/08	0174394	NIR:R-557065-1	7019		1213236471	881565899 RT0001	
QTE EXP QTY SHIPPED	DESCRIPTION			POIDS EXPÉDIÉ WEIGHT SHIPPED	PRIX - PRICE	UNITÉ UNIT	TOTAL
	304 180 GRIT						
5	3/4" SQ 18GA X 20'				28.00	PCS	140.00
	HEAT TUYU238460						
	Heat # 174394						
	SHIPPED WITH 174638						
<div>RECEIVED SEP 08 2008</div>							
Sub-Total							140.00
G.S.T.							7.00

FRAIS D'ADMINISTRATION DE 1½% PAR MOIS (18% PAR ANNÉE) SUR COMPTE PASSÉ DÙ.
LE PRÉSENT CONTRAT SERA RÉGI PAR LES LOIS DE LA PROVINCE DE QUÉBEC ET COMME
AYANT PRIS NAISSANCE DANS LE DISTRICT JUDICIAIRE DE MONTRÉAL.
ADMINISTRATION CHARGES OF 1½% PER MONTH (18% PER YEAR) ON OVERDUE ACCOUNTS.
THE PRESENT AGREEMENT SHOULD BE GOVERNED BY THE QUEBEC LEGISLATION AND SHOULD
BE CONSIDERED AS HAVING ORIGINATED IN THE JUDICIAL DISTRICT OF MONTREAL.

TOTAL →

147.00

Dart Aerospace Ltd

Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7
Phone: (613) 632-3336
Fax: (613) 632-4443

Receiving Slip

Date Sep 2, 2008	Page 1
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Receipt Number RCP00008763

Purchase From:

Magna Stainless
525 avenue Meloche
Dorval, QC H9P 2W2
Canada

Ship To:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7

Reference	Description	Contact	Vendor Number	PO Number
			VC-MAG002	PO00007019

Vendor Item Number	Item Number	Description	Qty. Received	UOM	Unit Cost	Extended Cost	Arrival Date
	M304TS0750W049	304 SQ Tube .75x.75x. MATERIAL: AISI 304/316 SS SQUARE TUBING B/N109087	100.0000 f		1.400000	140.00	Sep 02, 2008

Comments:

MAGNA

(INDUSTRIAL)

MAGNA STAINLESS DIV. DE CSM INC.
525 MELOCHE AVE.
DORVAL, QUEBEC H9P 2W2
(514) 631-1211 FAX: (514) 631-0013

COMMANDE
SALES ORDER

0174394

ADU À /
LD TO:

LIVRÉ À /
SHIP TO:

DART AEROSPACE LTD
270 ABERDEEN STREET
IAWKESBURY
ONTARIO

K6A 1K7

INSTRUCTIONS SPÉCIALES / SPECIAL INSTRUCTIONS

NIR: 0174394		DART		7019		613 632-5200		632-1053	
NIR: R-557065-1		NET 30		Aug-26-08		Aug-29-08		15 26 EB	
304 180 GRIT		3/4" SQ 18GA X 20'		100/474		5 pcs		K358	
TOTAL:								LBS	

IBRE DE PAQ.
IBER OF BOL'S

MTR-AVEC COMMANDE
MTR'S-WITH ORDER ☒

POSTE
MAIL ☐ TÉLÉCOPIEUR
FAX ☐

PACKING SLIP / BON D'EMBALLAGE

ge: 1
11:28:12 20080826

N° DE COULÉE ÉTAMPER SUR LE CÔTÉ
HEAT NO. STAMP ONE END ☐

MATÉRIEL REÇU EN BON ÉTAT PAR / MATERIAL RECEIVED IN GOOD CONDITIONS BY:



WINNER STAINLESS STEEL TUBE CO.,LTD

ORIGINAL



ADDRESS: 3RD INDUSTRIAL PARK, XIAOBU VILLAGE, HUASAN TOWN, HUADU DISTRICT, GUANGZHOU, P.R.C.
TEL: +86-20-86847851 FAX: +86-20-86941744

MILL TEST CERTIFICATE

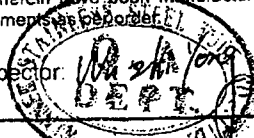
Issued Date: 2006/10/12

Certificate No.: GUL-F684

Customer:

Order No.: 119

00605129

Article: Stainless steel mechanical structures welded tube						Specification: ASTM A554-03						
Item No.	Size	Length	Qty, Pcs	Net Weight	Type	Heat No.	Annealed Temperature (°F)	Hold Time (minute)	Cooling	Surface Finish	Hydrostatic Test (psi)	ET
6~7#	3/4"SQ×18GA	20'	200	816.86	MT304	TU-YU238460	—	—	—	180Grit	—	—
8#	3/4"SQ×18GA	20'	48	196.05	MT304	TU-YU238460	—	—	—	180Grit	—	—
9~12#	3/4"SQ×16GA	20'	400	2145.80	MT304	TU-YU238951	—	—	—	180Grit	—	—
13#	3/4"SQ×16GA	20'	27	144.84	MT304	TU-YU238951	—	—	—	180Grit	—	—
14#	3/4"SQ×16GA	20'	19	101.93	MT304	TU-YU142400	—	—	—	180Grit	—	—
Chemical Composition (%)									Mechanical Test			
	C	Mn	P	S	Si	Ni	Cr	Mo	T. S. (Ksi)	Y. S. (Ksi)	Elongation (%)	Flattening
MIN						8.00	18.00	—	≥ 75	≥ 30	≥ 35	≤ 2/3D
MAX	0.080	2.00	0.040	0.030	1.00	11.00	20.00	—				
6~7#	0.025	1.49	0.038	0.004	0.47	8.08	18.14	—	95	51	52	good
8#	0.025	1.49	0.038	0.004	0.47	8.08	18.14	—	95	51	52	good
9~12#	0.026	1.44	0.031	0.005	0.36	8.09	18.29	—	99	49	55	good
13#	0.026	1.44	0.031	0.005	0.36	8.09	18.29	—	99	49	55	good
14#	0.023	1.41	0.035	0.007	0.44	8.09	18.21	—	92	50	51	good
Remarks: 1. Corrosion test: as per ASTM-A262, Practice E: accepted. 2. Dimensions & Visual: good. 3. Materials are free from mercury contamination.						We, Winner Stainless Steel Tube Co., Ltd., hereby certify that the products described herein have been manufactured in accordance with the standards and specifications specified as above and meet the requirements as per order.						
						Q. C. Manager/Work Inspector: 						

53693/53694/53695

**Purchase Order**

Date Aug 25, 2008	Page 1
Purchase Order Number PO00007019	

Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7
Phone: (613)632-9577
Fax: (613)632-1053

Vendor Address:

Magna Stainless
525 avenue Meloche
Dorval, QC H9P 2W2
Canada
Phone (800) 363-6646
Fax (514) 631-0013

Ship To:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7

Reference	Contact	Vendor Number VC-MAG002	PO Date Aug 25, 2008	Terms N30	Ship Via yours	Expected Arrival Aug 26, 2008
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Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
320.0000	M304S16GA	304/316 Sheet .063 Comments: MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH	8/26/2008	No	6.406250	sf	2.050.00
320.0000	M304S22GA	304/316 .032 Sheet Comments: AS ABOVE	8/26/2008	No	3.281250	sf	1.050.00
100.0000	M304TS0750W049	304 SQ Tube .75x.75x.0 Comments: MATERIAL: AISI 304/316 SS SQUARE TUBING	8/26/2008	No	1.400000	f	140.00
80.0000	M6061T6A1000W125	6061T6 ANGLE 1.00 x 1. Comments: MATERIAL: 6061-T6 /T6510/6511 ALUMINUM ANGLE PER AMS-QQ-A-200/8	8/26/2008	No	0.675000	f	54.00
200.0000	M6061T6TS1000W12	6061T6 SQ TUBE 1.00 x 1. Comments: MATERIAL: 6061-T6 OR 6061-T651/T6510/T6511/T62 SQUARE TUBING PER AMS-QQ-A-225/8 OR AMS 4117/4128/4115/4116 OR PER AMS-QQ-A-200/8 OR AMS 4160	8/26/2008	No	1.500000	f	300.00
<div>MATERIAL CERTIFICATION REQ'D UPON DELIVERY</div> <div>M108.57 M 108.057</div>							
Comments:		Tax Summary:		Less:			
		GST 179.70		included tax		0.00	
		ONT PST 0.00		Subtotal		3,594.00	
Entered By: CL CLAVOIE				Total tax		179.70	
Approved By:				Total purchase order in			
				CAD Dollars		3,773.70	